Work Orde February-12-14		5105		*-	113105	*						Page 1	
Revision ID:	D3595-063-39			Accept	*NO	nn	<b>040</b>	100	<b>)*</b> s	etup Sta Sto	171	S1* S2*	
	2/07/14	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*			Item II omer:	D:				· IV	<b>7</b>	
Approvals:		: MLZ	Date: 14-02-13	Tooling: SPC (Y/N			te:		R	un Sta Sto	"\\ D	R1* R2*	
Sequence ID/ Vork Center ID	)	Operation Description		Set Up Run H	•	ol ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revis	sion Nbr											
D3595	A												
00 <b>* 1 N N *</b> Waterjet FLOW CNC Waterje		FLOW WATER JET  Memo  1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if	r Dwg D3595	0.00					60	0		Jm14-03-2	5
10 *110* QC Quality Control		QC2- Inspect parts off n  Memo	nachine FAI/FAIB	0.00					60	_ \		Jm14-03-25	5
.20 <b>*1                                    </b>		QC8- Inspect parts - sec  Memo	ond check	0.00	27 14/3/26				60 coen				

DQA:		Date:			WORK ORDER NON	~	201501	2242105 / 111	DD 4 TE				DART
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOI	RIMANCE / U	PDATE	W	ork Order up	ndate only	AEROSPACE
					DISPOSITION				ACAINST				1.
Work Orde	er:				DISPOSITION				AGAINST	υc	PARTMENT, -	PROCESS	
					Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab	⊢	1	d. Eng. Coor.	Quality
NCD N	• .				Use-as-is			noforming	Finishing	-	Rec/Stor	re/Packaging	Other
NCR N	10				Suspected Unapproved	J		Large Fab	Composite		j	Supplier	
Root				Desci	ription of work order update		Initial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design													
Doc/Data	_												
Equip/Tooling					:								
Handling/Pre													
Material	_												
Operator	_					Ė							
Offset/Setup	_											•	
Process	_											:	
Supplier						1							
Training													
Transport	_												
Unapproved													
						FA	ULT CAT	EGORY					
Landir	ng Gear			_	General		1 .			_	7	_	7
	Bendin	~		<u> </u>	Bend		4	rogram		<u> </u>	Outside Dim	<b>⊢</b>	Pressure/Forced
		Not Conce	ntric		BOM/Route		Grain			<u> </u>	Over/Under		Set-up
	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			<u> </u>	Part Incorred	<u> </u>	Temperature/Cure
		Kink/Ripple	e/Wave		Burrs		1 '	on Incomplete/Ur	•	_	Part Lost/Mi		Weld
	Cuffs				Contamination		-{	ions Incomplete/l	Jnclear	<u> </u>	Part Moved		Wrong Stock Pulled
	Crushir				Countersink	$\vdash$		ned/off center		L	Positioned V		_ ا
	Heat T				Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge	Other
ļ		ion Strip in	Tube	<u> </u>	Drawing	<u> </u>	Misread	i					
		Chatter			Drill Holes	$\vdash$	Off-set						
	<del></del>	g Sequence		<u> </u>	Finish		4	Calibration					
	Wave/	Twist in Tu	he		Fit/Function	1	Out of	Seguence					

Work Order ID 113105

\*113105\*

Page 2

February-12-14 8:23:50 AM

Item ID:

D3595-063-395

Accept

\*N900040100\*

Setup Start

Stop

**Revision ID:** 

**Start Date:** 

**Item Name:** 

Required Date: 2/10/14

Rubber Cushion

2/07/14

**Start Qty:** 60.00 Req'd Qty: 60.00 \*60\* \*60\*

Cust Item ID:

Customer:

Reference:

**Approvals:** 

Process Plan: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/ **Work Center ID**  Operation

**Description** 

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Reject **Qty** 

Insp. Number Stamp

130

Identify as per dwg & Stock Location: 57412

0.00

Run

\*120\* Packaging

Packaging

Memo

QC: \_\_\_\_\_ Date:

0.00

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

Memo

0.00

Pl 14-03-26

QC Quality Control

DQA:		Date:										TRACT
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	odate only	AEROSPACE
M- 1 0-1-					DISPOSITION			A		PARTMENT	· · · · · · · · · · · · · · · · · · ·	
Work Orde	er:				,					1		
Part N	lo				Rework Scrap Use-as-is		•	Machining Sr	osstube mall Fab inishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo				Suspected Unapproved		inem	· · · · · · · · · · · · · · · · · · ·	mposite	nec/stol	Supplier	- Other
Root				Desc	ription of work order update	П	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector
Design									_			
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process			Į									
Supplier												
Training												
Transport											:	
Unapproved												
						FA	ULT CA	<b>TEGORY</b>				
Landi	ng Gear				General							
	Bending	ş			Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં [	Temperature/Cure
	Crimp/I	(ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclea	ar	Part Moved		Wrong Stock Pulled
	Crushin	g			Countersink		Misalig	ned/off center		Positioned V	Vrong	
	Heat Tr	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspect	ion Strip ir	Tube		Drawing		Misrea	b	_			
	Marks/	Chatter			Drill Holes		Off-set					
	Turning	Sequence	<b>!</b>		Finish		Out of	Calibration				
	Wave/1	wist in Tu	be		Fit/Function		Out of	Sequence				

**Picklist Print** 

February-12-14 8:23:54 AM

Work Order ID: 113105

D3595-063-395 **\***D

Parent Item:

Parent Item Name: Rubber Cushion

\*113105\*

\*D3595-063-395\*

**Start Date: 2/07/14** 

Required Date: 2/10/14

Page 1

Start Qty: 60.00

Required Qty: 60.00

**Comments:** 

IPP Rev:A 10.11.03 as per dwg revA DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit ( Meas	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595		Manufactured	No			100	sf	529.7004	0.0196	_1 <del>.23789</del> 6			
*D3595* Rubber Cushion (\$ Per Sq Fr	t)								**	Q :0		Jm	14-03-25
				<b>Location</b>		Loc (	<u> </u>	Loc Code					
				MAT052	•	529.7	004						
					68954	23	.707		_				
					84209	12.4	134						
					94539	49	3.58		$\mathcal{C}_{\mathcal{C}}$	14539.			

DQA:			Date:			WORK ORDER NON-	cc	NEOI	DNAANCE / HD	DATE					`DART
QA Closed:			Date:			WORK ORDER 14014-		JINFUI	NIVIAINCE / UP	DATE	W	ork Order up	odate only		AEROSPACE
Work Orde	or.	<u>-</u> -				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	lo					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng	Descri	ption		Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
							FA	ULT CA	regory						
Landir	B C C C C C H Ir N	ending entre No racks rimp/Kir uffs rushing eat Trea aspection	n Strip in	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Undictions Incomplete/Undicti	-		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Se Te W W	ressure/Forced et-up emperature/Cure /eld /rong Stock Pulled ther
	٧	/ave/Tw	ist in Tuk	oe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	1/3/05
Description: Rubber Cushion	Part Number:	D3595-063-395
Inspection Dwg: D3595 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/-0.030	0.642"	_		U	Jame <b>5</b>
3.95	+/-0.030	3.957"			U	
0.125	+/-0.010	0.642" 3.957" 0.128"	_		V	
			-			
			- PAC!			

Measured by: Tm	Audited by:	/9- <b>8</b> 9	Preliminary Approval:	
Date: 14-03.25	Date:	14/3/26	Date:	

Rev	Date	Change	Revised by Approve	)d
Α	08.01.23	New Issue	KJ/EC/DD	

<b>33</b> 3.9	。 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1	

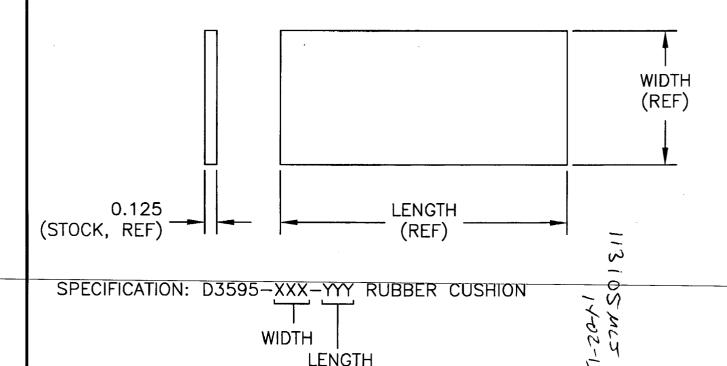
-2



DESIG	PH	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHECK	ED .	APPROVED //	DRAWING NO.	REV. A
		1	D3595	SHEET 1 OF 1
DATE			TITLE	SCALE
07.0	2.07		RUBBER CUSHION	NTS
A		07.02.07	NEW ISSUE	-



## SPECIFICATION CONTROL DRAWING



EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

## **NOTES**

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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